

**Claims**

1                   A method of making a container that includes the steps of:

2                   (a) providing a container having a neck,

3                   (b) providing a container attachment having a circumferentially continuous

4                   ring,

5                   (c) telescoping said ring over said neck, and

6                   (d) radially expanding at least a portion of said neck to secure said attachment

7                   to said neck.

2.

1                   The method set forth in claim 1 wherein said attachment has at least one external  
2                   thread segment.

3.

1                   The method set forth in claim 1 wherein said attachment includes a handle  
2                   coupled to said ring.

4.

1                   The method set forth in claim 1 wherein said step (a) includes providing at least  
2                   one external engagement element on said neck to engage said ring upon expansion of said neck  
3                   in said step (d).

5.

1           The method set forth in claim 4 wherein said step of providing at least one  
2       external engagement element includes providing spaced beads on said neck for engaging said  
3       ring.

6.

1           The method set forth in claim 1 wherein at least one of steps (a) and (b) includes  
2       providing at least one anti-rotational feature on at least one of said neck and said ring.

7.

1           The method set forth in claim 6 wherein said providing step includes providing  
2       knurling on at least one of said neck and said ring.

8.

1           The method set forth in claim 6 wherein said providing step includes providing  
2       at least one lug on one of said neck and said ring and at least one corresponding pocket on the  
3       other of said neck and said ring such that said at least one lug engages said at least one  
4       corresponding pocket.

9.

1           The method set forth in claim 1 wherein step (d) includes axially driving an anvil  
2       into said container to radially outwardly expand at least a portion of said neck into engagement  
3       with said attachment.

10.

1               The method set forth in claim 9 wherein said step (a) includes providing at least  
2       one external engagement element on said neck to engage said ring upon expansion of said neck  
3       in said step (d), further wherein said anvil simultaneously expands a finish portion of said neck  
4       and said at least one external engagement element on said neck.

11.

1               The method set forth in claim 9 wherein said step (a) includes providing at least  
2       one external engagement element on said neck to engage said ring upon expansion of said neck  
3       in said step (d), further wherein said anvil expands said at least one external engagement element  
4       on said neck but does not expand a finish portion of said neck.

12.

1               A container produced by the method of claim 1.

13.

1               A method of making a handled container that includes the steps of:  
2               (a)      providing a container having a neck,  
3               (b)      providing a handle having a circumferentially continuous ring,  
4               (c)      telescoping said ring externally over said neck, and  
5               (d)      radially expanding at least a portion of said neck to secure said handle to  
6       said neck.

14.

1           The method set forth in claim 13 wherein said attachment ring includes at least  
2        external thread forming an externally threaded finish when said ring is secured to said neck in  
3        said step (d).

15.

1           The method set forth in claim 13 wherein said neck includes at least one external  
2        thread, a capping flange, and a pair of spaced beads.

16.

1           The method set forth in claim 15 wherein said neck and said pair of spaced beads  
2        are smaller in diameter than that of said capping flange and said at least one external thread, and  
3        wherein said step (d) includes expanding that portion of said neck having said spaced beads  
4        without expanding that portion of said neck having said capping flange or said at least one  
5        external thread.

17.

1           The method set forth in claim 13 wherein at least one of steps (a) and (b) includes  
2        providing at least one anti-rotational feature on at least one of said neck and said ring of said  
3        handle.

18.

1           The method set forth in claim 17 wherein said providing step includes providing  
2        knurling on at least one of said neck and said ring of said handle.

19.

1           The method set forth in claim 17 wherein said providing step includes providing  
2       at least one lug on one of said neck and said ring and at least one corresponding pocket on the  
3       other of said neck and said ring such that said at least one lug engages said at least one  
4       corresponding pocket.

20.

1           The method set forth in claim 13 wherein step (d) includes axially driving an anvil  
2       into an open end of said container to radially outwardly expand at least a portion of said neck into  
3       engagement with said ring of said handle.

21.

1           A handled container produced by the method set forth in claim 1

22.

1           A method of making a handled container that includes the steps of:  
2           (a)      pressure molding a preform having a body and a neck with at least one  
3       external engagement element,  
4           (b)      providing a handle having a circumferentially continuous attachment ring,  
5           (c)      blow molding said body of said preform to form a body of a container  
6       having said neck extending therefrom, and  
7           (d)      either prior to or subsequent to said step (c):

8                             (d1)    telescoping said ring of said handle over said neck of said container until  
9    said ring is adjacent to said at least one external engagement element, and then  
10                            (d2)    expanding at least a portion of said neck containing said at least one  
11    external engagement element radially outwardly into engagement with said ring to secure said  
12    handle to said neck.

23.

1                           A handled container produced by the method set forth in claim 22.

24.

1                           A container that includes:

2                           a body,

3                           a neck extending from said body, and

4                           an attachment that includes an attachment ring encircling a portion of said neck,

5                           said portion of said neck being strain hardened by radial expansion against an

6    inside diameter of said attachment ring.

25.

1                           An attachment for a container having a body and a neck extending from said body  
2    wherein said neck includes a pair of external engagement beads, said attachment includes a ring  
3    having an internal diametrical surface having at least one anti-rotational engagement feature,  
4    wherein said attachment is adapted for securement to said neck of said container between said  
5    pair of external engagement beads by radially outward expansion of said neck and further  
6    wherein said pair of external engagement beads axially restrain said ring and said at least one

7 anti-rotational engagement feature rotationally restrains said ring from movement relative to said  
8 container.